

Work Order ID 80946

Monday, March 05, 2012 4:57:25 PM

80946Ship March 19th
Page 1

Item ID: D4018-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Short Basket Lid Assembly (350)

Start Date: 3/5/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/15/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *mc*

Date: 12-03-06 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4018

C

100

Weld per dwg A/R S.S. rod Batch: *4115778* 0.00
Large Fab***100***

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D4018 using DT9607B
2- weld hinge (3) and Mounting brackets as per dwg D4018
inspect before welding mesh
3- tack weld mesh on basket as per dwg D4018
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

*12-03-14 1X**12-03-15**1X*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

*** mask sides of hinge prior to powdercoat***

Start Time: 9h55Oven Temperature: 400°FFinish Time: 9h25

m145128

140

Wing Walk as per dwg QSI005 4.4 Batch m120125

0.00

140

HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

Install placard and label as per dwg

***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

1 & @/BL 12/03/16.

1XØ M/L 12/03/17

EP 12/03/19 @

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Cust Item ID:

Required Date: 3/15/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: 6A

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

EP12/03/19 @

EP12/03/19 @

MLJ 12/03/19
MF
12-03-19

Dart Aerospace Ltd

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Picklist Print

Monday, March 05, 2012 4:57:24 PM

Page 1

Work Order ID: 80946

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 3/5/2012

Required Date: 3/15/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15
verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D
as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4018-1 Rib		Manufactured	No			100	Each	8.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		8							
				72545		5							
				76381		3							
✓ D4018-3 Rib		Manufactured	No			100	Each	6.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		6							
				73032		6							
✓ D4016-3 Hinge Half, Lid		Manufactured	No			100	Each	21.0000	3	3			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		21							
				74909		3							
				78495		18							
✓ D4018-5 Rib		Manufactured	No			100	Each	18.0000	6	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		18							
				78404		2							
				80597		16							
✓ D4035-041 Lid Rib Assembly, Fwd (350 Basket)		Manufactured	No			100	Each	4.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		4							
				74642		4							

12.03.13

2x

12.03.13

2x

12.03.13

3x

12.03.13

6x

12.03.13

1x

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Page 2

Work Order ID: 80946

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 3/5/2012

Required Date: 3/15/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-043 Manufactured No
Lid Rib Assembly, Aft (350 Basket)

100 Each 2.0000 1

Location

Loc Qty

Loc Code

WA006

2

76545

2

12.03.13

✓ D2581 Manufactured No
Mounting Bracket

100 Each 43.0000 2

Location

Loc Qty

Loc Code

WA005

43

69739

1

70766

2

77045

11

77523

29

12.03.13

✓ D4020-7 Manufactured No
Mesh (350 Basket Short, Lid)

100 Each 0.0000 1

✓ D4021-3 Manufactured No
Data Plate

100 Each 4.0000 1

Location

Loc Qty

Loc Code

WA005

4

75460

4

B81388 → 1x 12.03.13

D2728-3 Manufactured No
Dart Logo label

140 Each 0.0000 1

12.03.13

12/02/19

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Shop Packet Print

Page 2

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

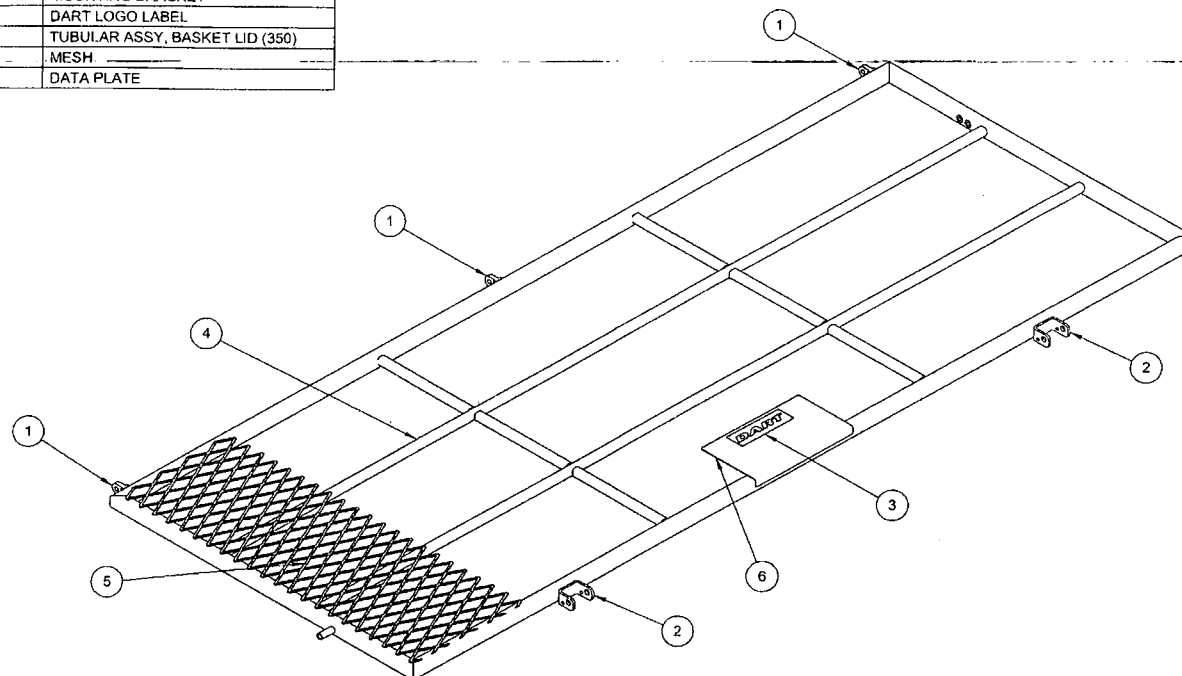
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. C
CHECKED	AS	D4018	SHEET 1 OF 4
MFG. APPR.	AS	TITLE	SCALE
APPROVED	AS	SHORT BASKET LID ASSY (350)	NTS
DE APPR.	AS	DATE 10.08.05	

RELEASED
10.08.12
ECN 10-946

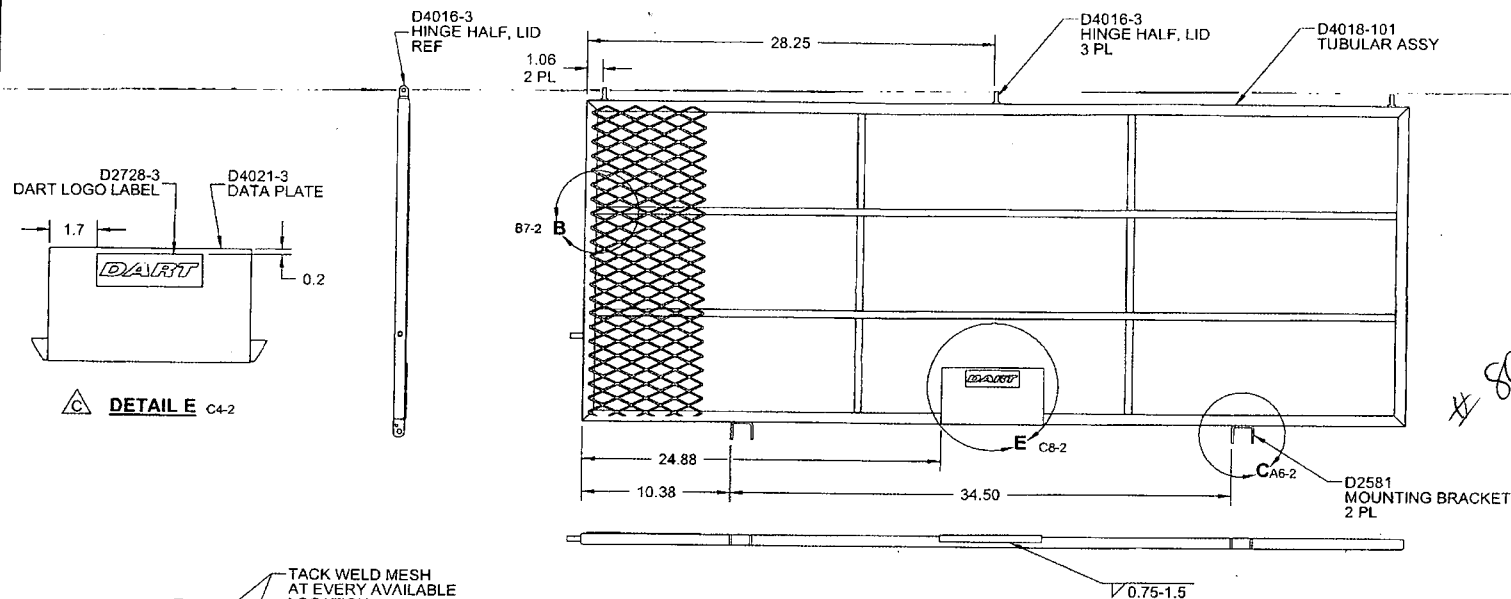
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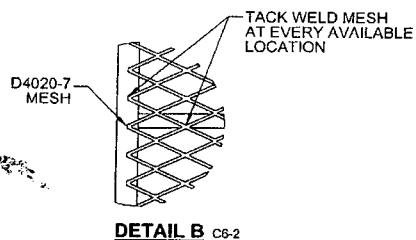
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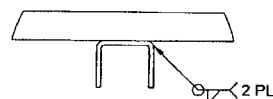


D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

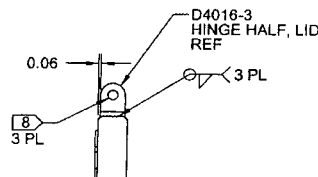
RELEASED
10.08.12



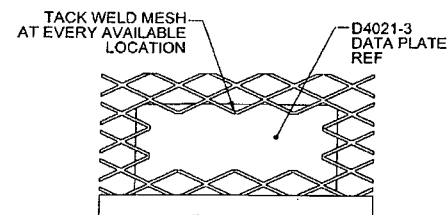
DETAIL B C6-2



DETAIL C C3-2



DETAIL D D1-2



VIEW A-A C1-2

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.5 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	AD	D4018	SHEET 2 OF 4
APPROVED	AD	TITLE	SCALE
DE APPR.	AD	SHORT BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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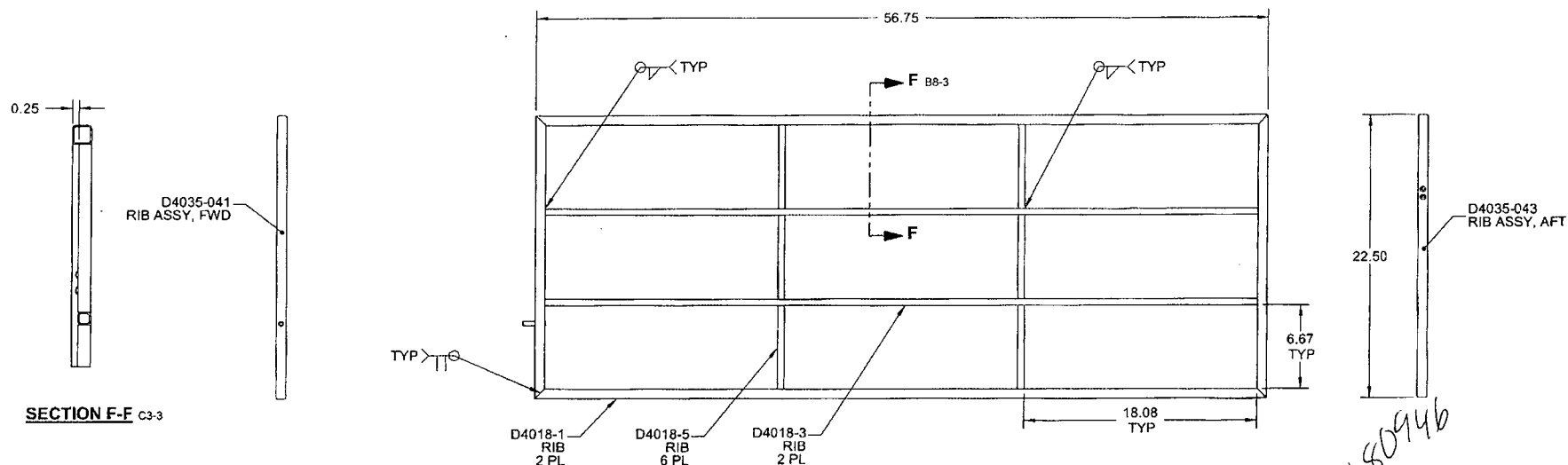
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.08 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	115	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4018	SHEET 3 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	SHORT BASKET LID ASSY (350) NTS	
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RELEASED
10.08.12

#80946

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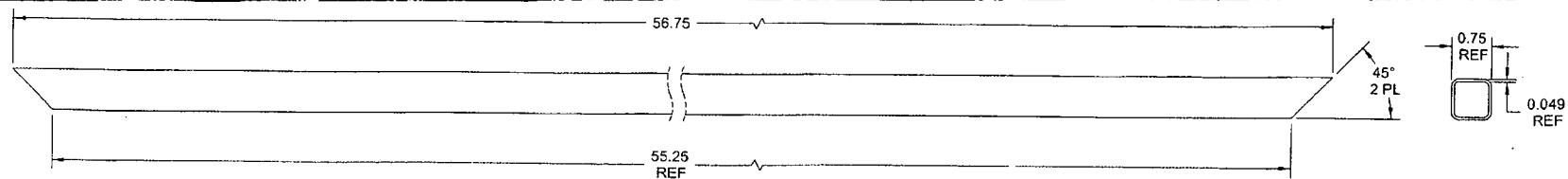
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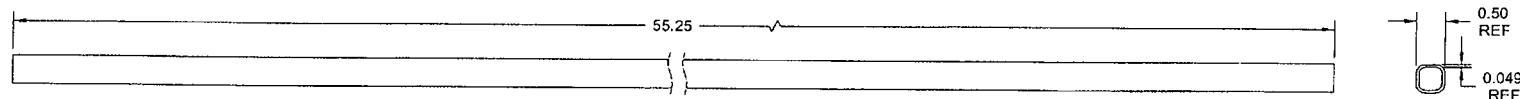
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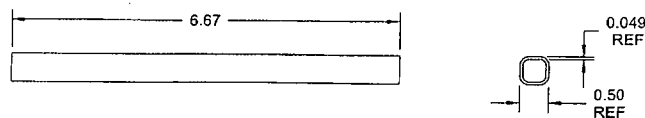
D4018-1 RIB

C



D4018-3 RIB

B



D4018-5 RIB

#80946

RELEASED
10.08.05

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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8 7 6 5 4 3 2 1

A

A

Dart Aerospace Ltd

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